



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D412-698-023
Job Sheet 186929



Part No: D412-698-023

Job Qty: 4 ea

Part Name: Automatic Door Opener (fits LH or RH)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN-D412-698 REV.G IPP Rev:A New Issue 07-07-12 JLM IPP rev B ecn 1207 08.07.03 EC verified by:LL

Ship Via:

684/

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Stores/Pkg-2	9-89	DAS 6 DEC 04 2018
110	Packaging	4 pcs	12/7/18	12/7/18	0.00	0.00	Packaging1-4	9-89	DAS 6 DEC 11 2018
120	QC	4 pcs	12/7/18	12/7/18	0.00	0.00	QC4	9-89	DAS 69 DEC 11 2018
130	Packaging	4 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-2	9-89	DAS 69 DEC 11 2018
135	DC	4 pcs	12/7/18	12/7/18	0.00	0.00	DC	9-89	DAS 21 DEC 12 2018
140	QC21-FG	4 Ea	12/7/18	12/7/18	0.00	0.00	QC21	9-89	DAS 21 DEC 12 2018

Part Op Descriptions: 135 - Photocopy bluefile & type labels per PPP D412-698-023 CHG003

DAS 21
9-89
DEC 12 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3552-11	Door Prop	4 Ea (1 ea)	90-Start up Operation	3120724
D3594-043	Floor Doubler Assembly, LH	4 Ea (1 ea)	90-Start up Operation	5133302
D3594-044	Floor Doubler Assembly, RH	4 Ea (1 ea)	90-Start up Operation	5133283
D3594-5	Doubler	4 Ea (1 ea)	90-Start up Operation	5121007
D3622-1	Ball Stud	8 Ea (2 ea)	90-Start up Operation	5142183X1 5130653
MS20426AD4-4	Rivet	8 Ea (2 ea)	90-Start up Operation	712544504
MS21073L5	Anchor Nut	4 Ea (1 ea)	90-Start up Operation	5123467
NAS1149D0516J	Washer	8 Ea (2 ea)	90-Start up Operation	5007015

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3552-11	4	8	0
	D3594-043	4	1	0
	D3594-044	4	2	0
	D3594-5	4	7	0
	D3622-1	8	7	0
	MS20426AD4-4	8	2,961	0
	MS21073L5	4	20	0
	NAS1149D0516J	8	70	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																				

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
--------	---------	-----------------	-----------------------

Description Work Order Deviation 	Disposition 	Completed By
		Lead hand / Supervisor Approval Verification

Root Cause <table border="0"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	FAULT CATEGORY <table border="0"> <tr><td>Pressure/Forced</td><td>☐</td><td>Temperature/Cure</td><td>☐</td><td>Power Loss/s</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td><td>Set-up</td><td>☐</td><td>Folio/Prograr</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incomplete/Unqualified</td><td>☐</td><td>Wrong Stock</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td><td>Out of Sequel</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td><td>Off-set</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td><td>Mislabeled</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incomplete/Unclear</td><td>☐</td><td>Fit/Function</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Misaligned/of</td><td>☐</td></tr> </table>		Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/s	☐	Bending	☐	Set-up	☐	Folio/Prograr	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock	☐	Cuffs	☐	Contamination	☐	Out of Sequel	☐	Crushing	☐	Countersink	☐	Off-set	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/of	☐
Environment	☐	No Re-verification	☐																																																																																																												
Design	☐	Operator	☐																																																																																																												
Doc/Data	☐	Offset/Setup	☐																																																																																																												
Equip/Tooling	☐	Supplier	☐																																																																																																												
Handling/Pre	☐	Training	☐																																																																																																												
Material	☐	Use for Testing	☐																																																																																																												
Internal Transport	☐	Poor Information	☐																																																																																																												
Tribal Knowledge	☐	Rushing	☐																																																																																																												
LOA	☐	Product Improvement	☐																																																																																																												
Substation	☐	Process Improvement	☐																																																																																																												
Past Expiry Date	☐	Manufacturing Process	☐																																																																																																												
Misidentified	☐	Past Due	☐																																																																																																												
Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/s	☐																																																																																																										
Bending	☐	Set-up	☐	Folio/Prograr	☐																																																																																																										
Centre Not Concentric	☐	BOM/Route	☐	Grain	☐																																																																																																										
Cracks	☐	Broken/Damage/Defect	☐	Weld	☐																																																																																																										
Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock	☐																																																																																																										
Cuffs	☐	Contamination	☐	Out of Sequel	☐																																																																																																										
Crushing	☐	Countersink	☐	Off-set	☐																																																																																																										
Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐																																																																																																										
Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐																																																																																																										
Marks/Chatter	☐	Drill Holes	☐	Misaligned/of	☐																																																																																																										
OTHER :																																																																																																															

Container No: S136792
 Part: D412-698-023
 Job No: 186929
 Serial No/Batch: S136792
 Revision: G
 Inspector:
 Exp Date:
 Instructions: TC STC SH92-43 Issue

DART Aerospace Ltd.
 1270 Aberdeen Street
 Hawthornbury, ON K6A 1K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Specifications could not be found.

Plex 11/22/18 2:50 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

PAGE 1 OF 1

Description: AUTOMATIC DOOR OPENER INSTALLATION

[illegible]

